

[illegible]

Monday, February 28, 2011 11:39:01 AM

Accept

**Setup Start**[illegible]

Stop

[illegible]

Start Date: 2/28/2011 **Start Qty:** 5.00

.Cust Item ID:

Required Date: 3/4/2011 **Req'd Qty:** 5.00

[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:**

Date: 11-02-28 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66826

Monday, February 28, 2011 11:39:01 AM



Page 2

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 2/28/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo 1-Thermoform as per Dwg D3136 and Folio FTA006 <input type="checkbox"/> Dwg Rev. <u>E</u> <input type="checkbox"/> Folio Rev. <u>C</u> <input type="checkbox"/> 2- Engrave Part # and Batch # , and affix labels <input type="checkbox"/> (D3108-9)	0.00 0.00				25	(+0)		Sh 11/03/04 PTO. →
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							Sh 11/03/04
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(+5)			

W/O: 66826		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/03/04	130						

Part No: 03136-041 PAR #: _____ Fault Category: Thermoforming NCR: Yes No DQA: [Signature] Date: 11/03/08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/12/08

NCR: 11-1041		WORK ORDER NON-CONFORMANCE (NCR) 50.34						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/04	130	1 window slightly overheated causing waves on edge. R.L. Process	[Signature] 11/03/04	Scrap 1 window. no replace	11/03/04 Dr.	S 11/03/08	[Signature] 11/03/08	S 11/03/08

NOTE: Date & initial all entries

Work Order ID 66826

Monday, February 28, 2011 11:39:01 AM

Page 3

Item ID: D3136-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Window Assembly

Start Date: 2/28/2011 Start Qty: 5.00

Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



Thermoform

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

11/03/07

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Inspect edge and window deformation, wrap in plastic

180



Packaging

Identify as per dwg & Stock Location: ST215 0.00

Memo

0.00

Packaging

5X 8011-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 66826

Monday, February 28, 2011 11:39:01 AM

Page 4

Item ID: D3136-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Window Assembly

Start Date: 2/28/2011 Start Qty: 5.00

Required Date: 3/4/2011 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/5 *[Signature]**MF*
11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, February 28, 2011 11:39:08 AM

Work Order ID: 66826

Parent Item: D3136-041

Parent Item Name: Window Assembly



Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B 04.02.04 Reformat KJ/DS
IPP C Thermoform in house 05/07/2007 DL
IPP D Rev E 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3108-9  Decal		Manufactured	No			100	Each	628.0000	2	10			
<div> <div>Location</div> <div>ST033</div> <div>34554</div> <div>46546</div> </div> <div> <div>Loc Qty</div> <div>628</div> <div>128</div> <div>500</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
MACRLICS.125  1/8" Polycast II Sheet		Purchased	No			170	sf	128.4222	4.25	22.36842			
<div> <div>Location</div> <div>MAT</div> <div>114673</div> <div>115338</div> </div> <div> <div>Loc Qty</div> <div>128.4222</div> <div>1.1722</div> <div>127.25</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

Sh.
11/03/07

30
1311-3-1

(6)

115388

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

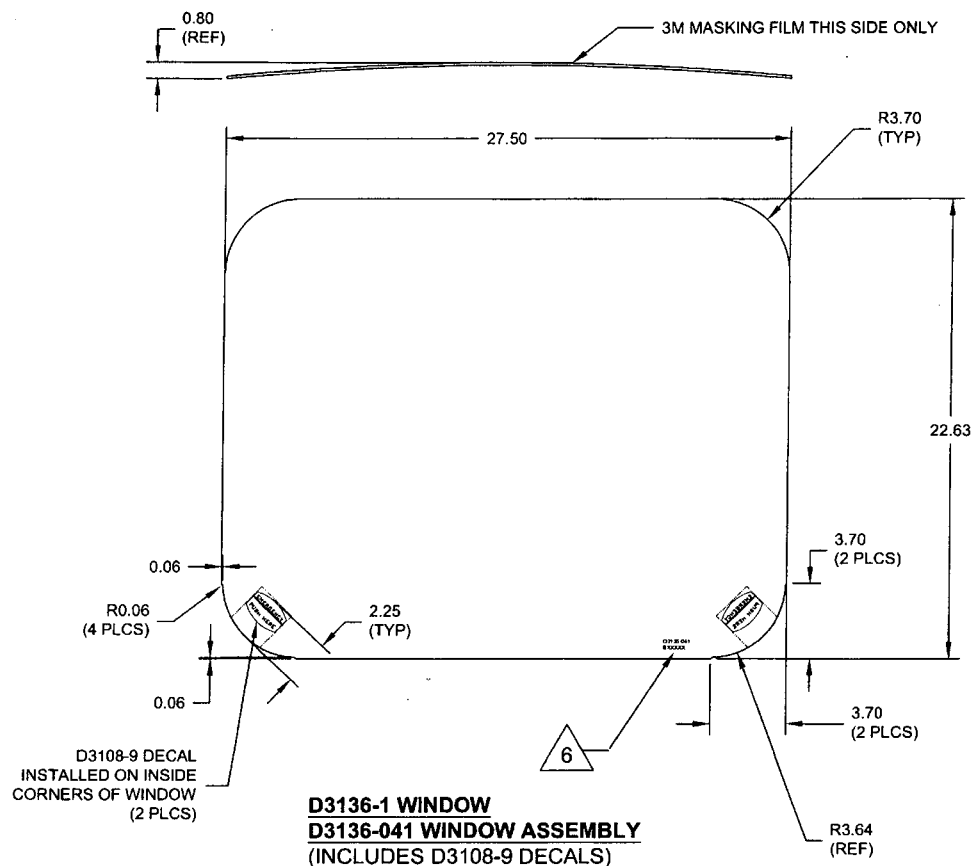
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64824

MOLD PER
DART TOOL
DT3136-T1

R140
(REF)

0.125
(REF)

0.58
(REF)

RELEASED
07.09.22

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3136
REV. E
SHEET 1 OF 2
TITLE WINDOW ASSEMBLY
SCALE 1:6

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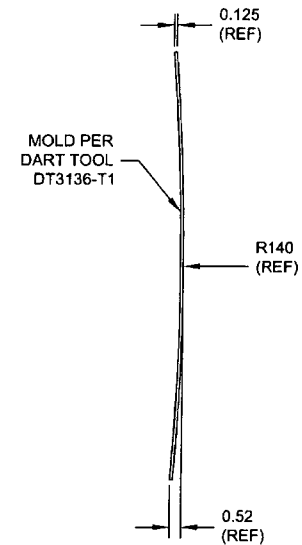
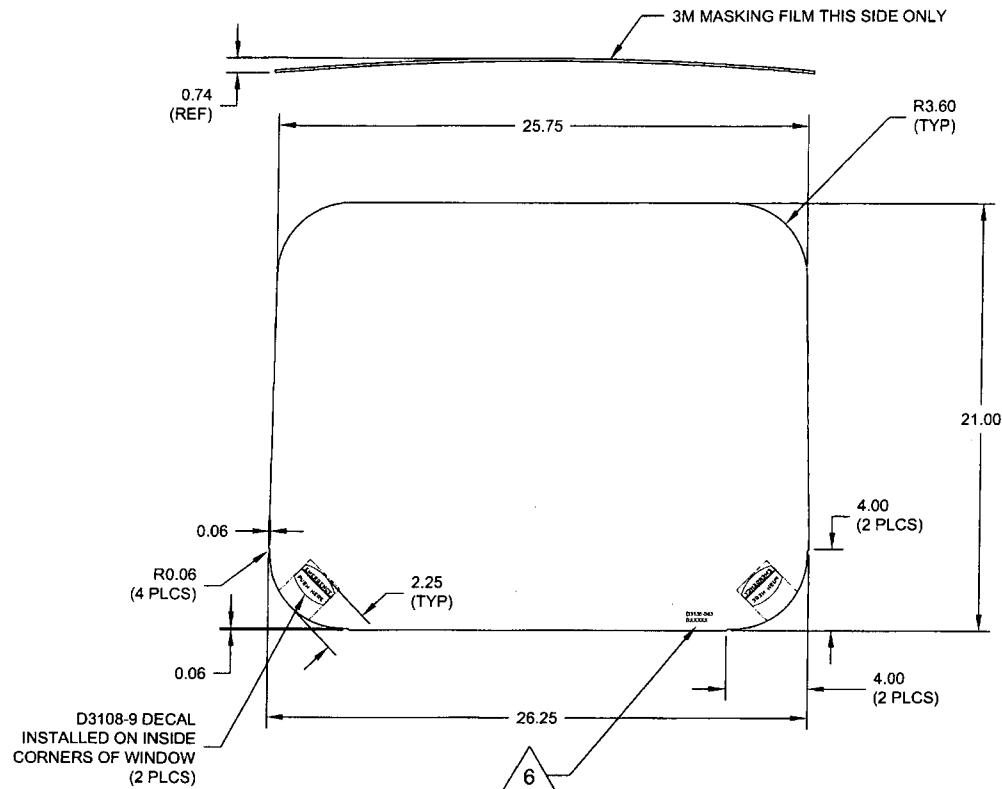
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NOTE: Date & initial all entries



w/c 66824

**D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)**

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
07.09.22

DESIGN	4	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JC	DRAWING NO.	REV. E
MFG. APPR.	JC	D3136	SHEET 2 OF 2
APPROVED	JC	TITLE	SCALE
DE APPR.	JC	WINDOW ASSEMBLY	1:6
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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